

Work Order ID 144751

May 05, 2016 9:22:39 AM

Need!
144751

Page 1

Item ID: D4078-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp Half

Start Date: 5/16/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 05 2016

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4078	B								

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.700" long

20 X 16/25/10

110

0.95

110

HAAS 1

Memo

5.60

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA929

Folio rev: AA

Dwg Rev: B

Deburr

20 X 16/25/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

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N900040100

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Revision ID:

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Stop *NS2*

Start Date: 5/16/2016 **Start Qty:** 20.00

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Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 20.00

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Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

[illegible]

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

OC

Memo

0.20

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.40

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0,00

140

HandFinish

Memo

0.60

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																													
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Work Order ID 144751

May 05, 2016 9:22:39 AM

144751

Page 3

Item ID: D4078-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp Half

Start Date: 5/16/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan

Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

START: 10:10

150

Powdercoat

M127777

0.20

W. T: 320°

20 16-05-20 333

Powder Coating

Memo

FINISH: 10:40.

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.20

20

DAS
38
9-88

MAY 24 2016

Quality Control

170

Identify as per dwg & Stock Location: *54072*

0.00

170

Packaging

Memo

0.20

20
DAS
6
9-89

MAY 25 2016

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 				
Description Work Order Deviation				Disposition							
								Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong						
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions						
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Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	2.00							
Quality Control									

1615/25 JF

MW MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

May 05, 2016 9:22:39 AM

Page 1

Work Order ID: 144751

144751

Parent Item: D4078-1

D4078-1

Parent Item Name: Clamp Half

Start Date: 5/16/2016

Required Date: 5/30/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased		No		100	f	14.2640	0.223	4.694736			

M6061T6B1 250X01 250

6061-T6 Bar 1.25 x 1.25

16/05/10

Location

Loc Qty

Loc Code

MAT003

14.264

m126647

0.246

m128247

1.838

m132772

1.98

m133699

10.2

4,583

DQA: _____ Date: _____



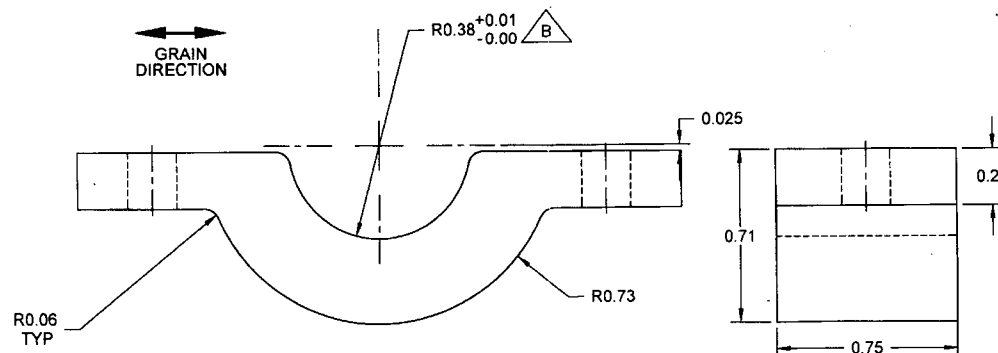
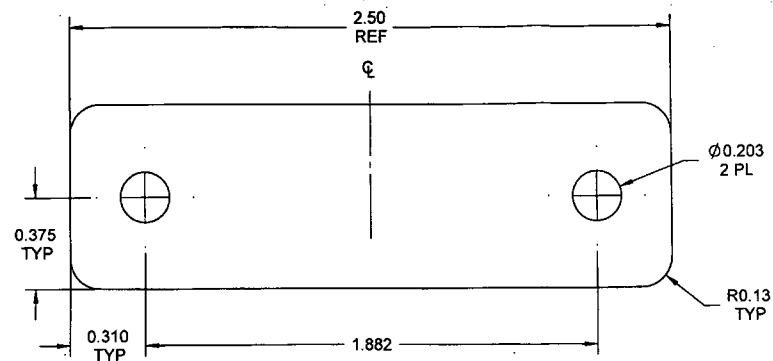
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						



D4078-1 CLAMP HALF

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

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144751 MJS
10-05-05

RELEASED
2010-09-07
WP

B	R0.38 was R0.48.	JB	10.07.30
A	NEW ISSUE	JB	10.02.08
REV	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB		
DATE	10.07.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4078	REV. B SHEET 1 OF 1
TITLE CLAMP HALF	SCALE NTS
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